

Date: Wednesday, 3/7/2007 3:53:11 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350 SADDLE
Job Number	: 31076		
Estimate Number	: 12451		
P.O. Number	: <i>N/A</i>	Part Number	: D35001
This Issue	: 3/7/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D3500 REV C
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 28794	Drawing Revision	: C
		Material	: <i>N/A</i>
Written By	:	Due Date	: 3/30/2007
Checked & Approved By	: <i>[Signature]</i> 07.03.07	Qty:	48 Um: Each
Comment	: Est Rev: A New Issue 06-06-15 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	D6102013	6061-T6 7.0x6.5x2.0
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 48.0000 Each(s)

6061-T6 7.0x6.5x2.0

350 Saddle Billet

Batch: *B28811**J.F. 07/04/08**(38)*

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. *J.F.* Double check by: *SD*

1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA641 and inspect per attached Dimension Sheets

4-Deburr

5-Tumble to remove sharp edges.

*J.L / J.F. 07/04/13**(37)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*J.L / J.F. 07/04/13**(37)*

4.0	QC8	SECOND CHECK
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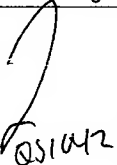



Comment: SECOND CHECK

*9mk 07/04/15**(37)*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: ED Date: 07/04/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/04/11	2	-1 saddle is scrap, the rougher pulled out of holder because of vibration	 Q51042	- scrap, destroy No replace	J.L 07/04/11	 07/04/11	 Q51042	 07/04/11

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 3:53:11 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SADDLE

Job Number: 31076

Part Number: D35001

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL

07/04/16

(37)

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL

07-04-16

(37)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/04/16 (37)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

07/04/16 (37)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(37)

Comment: FINAL INSPECTION/W/O RELEASE

07/04/18

Job Completion



07/04/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	31076
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.486"	.486"	.486"	.486"		
B	1.175	1.185		1.179"	1.179"	1.179"	1.179"		
C	3.145	3.155		3.151"	3.151"	3.151"	3.151"		
D	1.175	1.185		1.179"	1.179"	1.179"	1.179"		
E	0.365	0.385		.375"	.375"	.375"	.375"		
F	0.490	0.510		.501"	.501"	.500"	.499"		
H	R.470	R.530		R.525"	R.525"	R.525"	R.525"		
I	R1.575	R1.595		R1.586"	R1.589"	R1.592"	R1.595"		
J	0.240	0.260		.243"	.255"	.252"	.248"		
K	0.490	0.510		.501"	.499"	.499"	.500"		
L	3.590	3.650		3.620"	3.620"	3.620"	3.620"		
M	0.315	0.320		Ø.320"	Ø.320"	Ø.320"	Ø.320"		
N	0.256	0.262		Ø.259"	Ø.259"	Ø.259"	Ø.259"		
O	6.500	6.520		6.507"	6.507"	6.510"	6.510"		
P	5.990	6.010		6.001"	6.001"	6.001"	6.001"		
Q	2.820	2.830		2.825"	2.825"	2.825"	2.825"		
R	2.495	2.505		2.501"	2.501"	2.501"	2.501"		
S	2.245	2.255		2.255"	2.255"	2.255"	2.255"		
T	1.120	1.130		1.127"	1.127"	1.127"	1.127"		
U	0.540	0.560		.553"	.553"	.553"	.540"		
V	0.793	0.803		.798"	.798"	.798"	.798"		
W	R.240	R.260		R.250"	R.250"	R.250"	R.250"		
X	0.040	0.060		.040"	.050"	.050"	.050"		
Y	0.100	0.120		.110"	.110"	.110"	.110"		
AA	R1.125	R1.145		R1.135"	R1.137"	R1.141"	R1.145"		
AB	R.490	R.510		R.500"	R.500"	R.500"	R.500"		
AC	0.615	0.635		.630"	.630"	.630"	.630"		
AD	0.240	0.260		.240"	.253"	.250"	.244"		
AE	1.810	1.830		1.812"	1.823"	1.827"	1.826"		
AF	0.240	0.260		.240"	.254"	.253"	.250"		
AG	0.140	0.160		.140"	.153"	.152"	.151"		
AH	0.140	0.160		.145"	.152"	.150"	.147"		
AI	0.140	0.160		.140"	.148"	.148"	.150"		
Accept/Reject									

Measured by:	J.F.
Date:	07/04/09

Audited by:	Gr
Date:	07/04/15

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

DART AEROSPACE LTD		Work Order:	31076
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		Ø .486"	.486	.486	.486		
B	1.175	1.185		1.179"	1.179	1.179	1.179		
C	3.145	3.155		3.151"	3.150	3.150	3.150		
D	1.175	1.185		1.179"	1.178	1.180	1.179		
E	0.365	0.385		.375"	.370	.372	.373		
F	0.490	0.510		.500"	.499	.500	.498		
H	R.470	R.530		R.525"	.525	.525	.525		
I	R1.575	R1.595		R1.586"	1.581	1.578	1.586		
J	0.240	0.260		.257"	.255	.255	.252		
K	0.490	0.510		.501"	.500	.501	.499		
L	3.590	3.650		3.620"	3.620	3.620	3.620		
M	0.315	0.320		Ø .320"	.320	.320	.320		
N	0.256	0.262		Ø .259"	.259	.259	.259		
O	6.500	6.520		6.510"	6.510	6.510	6.510		
P	5.990	6.010		5.997"	5.996	5.999	5.999		
Q	2.820	2.830		2.825"	2.825	2.825	2.825		
R	2.495	2.505		2.501"	2.500	2.500	2.500		
S	2.245	2.255		2.255"	2.250	2.250	2.250		
T	1.120	1.130		1.127"	1.124	1.125	1.124		
U	0.540	0.560		.544"	.549	.550	.551		
V	0.793	0.803		.798"	.798	.797	.798		
W	R.240	R.260		R.250"	.250	.250	.250		
X	0.040	0.060		.050"	.050	.050	.050		
Y	0.100	0.120		.110"	.110	.110	.110		
AA	R1.125	R1.145		R1.136"	R1.132	1.130	1.136		
AB	R.490	R.510		R.500"	.500	.500	.500		
AC	0.615	0.635		.630"	.635	.635	.635		
AD	0.240	0.260		.255"	.252	.252	.250		
AE	1.810	1.830		1.824"	1.822	1.823	1.821		
AF	0.240	0.260		.250"	.248	.248	.250		
AG	0.140	0.160		.151"	.148	.149	.147		
AH	0.140	0.160		.155"	.155	.155	.150		
AI	0.140	0.160		.155"	.156	.155	.151		
Accept/Reject									

Measured by:	J.F.
Date:	07/04/09 / 07/04/10

Audited by:	amr
Date:	07/04/15

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

DART AEROSPACE LTD		Work Order:	31076
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.180	1.178	1.178	1.179		
C	3.145	3.155		3.150	3.149	3.150	3.150		
D	1.175	1.185		1.178	1.180	1.178	1.179		
E	0.365	0.385		.373	.374	.374	.375		
F	0.490	0.510		.498	.498	.500	.499		
H	R.470	R.530		.525	.525	.525	.525		
I	R1.575	R1.595		1.587	1.584	1.585	1.585		
J	0.240	0.260		.250	.251	.251	.250		
K	0.490	0.510		.499	.500	.499	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.320		.320	.320	.320	.320		
N	0.256	0.262		.259	.259	.259	.259		
O	6.500	6.520		6.510	6.509	6.509	6.509		
P	5.990	6.010		5.998	5.999	5.999	5.999		
Q	2.820	2.830		2.825	2.825	2.825	2.824		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.124	1.125	1.124	1.125		
U	0.540	0.560		.551	.550	.551	.551		
V	0.793	0.803		.797	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.138	1.135	1.135	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.249	.250	.250	.250		
AE	1.810	1.830		1.824	1.823	1.822	1.821		
AF	0.240	0.260		.249	.250	.250	.249		
AG	0.140	0.160		.149	.150	.150	.150		
AH	0.140	0.160		.149	.151	.150	.151		
AI	0.140	0.160		.150	.150	.152	.152		
Accept/Reject									

Measured by:	J.L.
Date:	07/04/10

Audited by:	cmk
Date:	07/04/15

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

DART AEROSPACE LTD		Work Order:	31076
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.179	1.180	1.180	1.179		
C	3.145	3.155		3.150	3.149	3.149	3.150		
D	1.175	1.185		1.179	1.178	1.180	1.180		
E	0.365	0.385		.374	.374	.374	.374		
F	0.490	0.510		.499	.498	.498	.500		
H	R.470	R.530		.525	.525	.525	.525		
I	R1.575	R1.595		1.585	1.586	1.588	1.586		
J	0.240	0.260		.252	.252	.250	.251		
K	0.490	0.510		.498	.499	.498	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.320		.320	.320	.320	.320		
N	0.256	0.262		.259	.259	.259	.259		
O	6.500	6.520		6.508	6.509	6.510	6.509		
P	5.990	6.010		5.999	5.999	5.999	6.001		
Q	2.820	2.830		2.825	2.826	2.825	2.825		
R	2.495	2.505		2.500	2.499	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.124		
U	0.540	0.560		.551	.551	.550	.551		
V	0.793	0.803		.797	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.135	1.137	1.138	1.136		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.248	.251	.248	.249		
AE	1.810	1.830		1.823	1.822	1.822	1.822		
AF	0.240	0.260		.249	.250	.251	.250		
AG	0.140	0.160		.150	.152	.151	.152		
AH	0.140	0.160		.148	.150	.150	.151		
AI	0.140	0.160		.152	.149	.151	.149		
Accept/Reject									

Measured by:	J.L.
Date:	07/04/10

Audited by:	Amk
Date:	07/04/15

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

DART AEROSPACE LTD		Work Order:	31076
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.180	1.180	1.179	1.180		
C	3.145	3.155		3.150	3.149	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.179	1.180		
E	0.365	0.385		.374	.374	.374	.374		
F	0.490	0.510		.500	.498	.500	.499		
H	R.470	R.530		.525	.525	.525	.525		
I	R1.575	R1.595		1.585	1.579	1.587	1.586		
J	0.240	0.260		.252	.250	.250	.250		
K	0.490	0.510		.499	.500	.499	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.320		.320	.320	.320	.320		
N	0.256	0.262		.259	.259	.259	.259		
O	6.500	6.520		6.510	6.510	6.509	6.510		
P	5.990	6.010		5.999	6.000	5.999	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.249	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.124	1.125		
U	0.540	0.560		.552	.550	.551	.550		
V	0.793	0.803		.798	.797	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.136	1.130	1.137	1.136		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.250	.251	.250	.250		
AE	1.810	1.830		1.822	1.822	1.823	1.823		
AF	0.240	0.260		.250	.240	.251	.250		
AG	0.140	0.160		.151	.144	.152	.151		
AH	0.140	0.160		.151	.148	.150	.150		
AI	0.140	0.160		.150	.149	.150	.151		
Accept/Reject									

Measured by:	JL
Date:	07/04/11

Audited by:	cmf
Date:	07/04/15

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	



DART AEROSPACE LTD		Work Order:	31076
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.180	1.180"	1.180"	1.180"		
C	3.145	3.155		3.150	3.150"	3.150"	3.150"		
D	1.175	1.185		1.179	1.180"	1.180"	1.180"		
E	0.365	0.385		.374	.374	.374	.374		
F	0.490	0.510		.499	.499"	.499"	.499"		
H	R.470	R.530		.525	.525	.525	.525		
I	R1.575	R1.595		1.587	1.586	1.588"	1.587"		
J	0.240	0.260		.250	.255"	.255"	.258"		
K	0.490	0.510		.499	.500"	.500"	.500"		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.320		.320	.320	.320	.320		
N	0.256	0.262		.259	.259	.259	.259		
O	6.500	6.520		6.509	6.510"	6.510"	6.510"		
P	5.990	6.010		5.999	6.003"	6.000"	5.997"		
Q	2.820	2.830		2.825	2.825	2.825"	2.825"		
R	2.495	2.505		2.500	2.502"	2.502"	2.501"		
S	2.245	2.255		2.249	2.253"	2.253"	2.253"		
T	1.120	1.130		1.125	1.126"	1.126"	1.126"		
U	0.540	0.560		.549	.553"	.545"	.545"		
V	0.793	0.803		.798	.798"	.798"	.798"		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.137	1.136"	1.137"	1.136"		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.251	.255"	.252"	.250"		
AE	1.810	1.830		1.823	1.823"	1.823"	1.823"		
AF	0.240	0.260		.252	.249"	.253"	.250"		
AG	0.140	0.160		.153	.154"	.153"	.154"		
AH	0.140	0.160		.151	.153"	.152"	.150"		
AI	0.140	0.160		.151	.150"	.155"	.155"		
Accept/Reject									

Measured by:	J.L. / J.F.
Date:	07/04/11

Audited by:	amk
Date:	07/04/15

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

DART AEROSPACE LTD		Work Order:	31076
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		Ø.486"	Ø.486"	Ø.486"	Ø.486"		
B	1.175	1.185		1.180"	1.180"	1.180"	1.180"		
C	3.145	3.155		3.150"	3.150"	3.150"	3.150"		
D	1.175	1.185		1.180"	1.180"	1.180"	1.180"		
E	0.365	0.385		.377"	.377"	.377"	.377"		
F	0.490	0.510		.500"	.498"	.500"	.499"		
H	R.470	R.530		R.525"	R.525"	R.525"	R.525"		
I	R1.575	R1.595		R1.590"	R1.588"	R1.588"	R1.588"		
J	0.240	0.260		.258"	.258"	.257"	.256"		
K	0.490	0.510		.500"	.500"	.500"	.500"		
L	3.590	3.650		3.620"	3.620"	3.620"	3.620"		
M	0.315	0.320		Ø.320"	Ø.320"	Ø.320"	Ø.320"		
N	0.256	0.262		Ø.259"	Ø.259"	Ø.259"	Ø.259"		
O	6.500	6.520		6.510"	6.510"	6.510"	6.511"		
P	5.990	6.010		5.995"	6.000"	5.998"	5.997"		
Q	2.820	2.830		2.825"	2.825"	2.825"	2.825"		
R	2.495	2.505		2.502"	2.502"	2.502"	2.502"		
S	2.245	2.255		2.253"	2.253"	2.253"	2.253"		
T	1.120	1.130		1.126"	1.126"	1.126"	1.126"		
U	0.540	0.560		.545"	.545"	.546"	.546"		
V	0.793	0.803		.798"	.798"	.798"	.798"		
W	R.240	R.260		R.250"	R.250"	R.250"	R.250"		
X	0.040	0.060		.045"	.045"	.045"	.045"		
Y	0.100	0.120		.110"	.110"	.110"	.110"		
AA	R1.125	R1.145		R1.138"	R1.137"	R1.136"	R1.136"		
AB	R.490	R.510		R.500"	R.500"	R.500"	R.500"		
AC	0.615	0.635		.635"	.635"	.635"	.635"		
AD	0.240	0.260		.250"	.250"	.252"	.250"		
AE	1.810	1.830		1.823"	1.823"	1.823"	1.823"		
AF	0.240	0.260		.251"	.249"	.250"	.248"		
AG	0.140	0.160		.155"	.153"	.153"	.153"		
AH	0.140	0.160		.152"	.151"	.151"	.152"		
AI	0.140	0.160		.155"	.154"	.154"	.155"		
Accept/Reject									

Measured by:	J.F.
Date:	07/04/12

Audited by:	gmk
Date:	07/04/15

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	gmk

DART AEROSPACE LTD		Work Order:	31076
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		Ø .486"	Ø .486"	Ø .486"	Ø .486"		
B	1.175	1.185		1.180"	1.180"	1.180"	1.180"		
C	3.145	3.155		3.150"	3.150"	3.150"	3.150"		
D	1.175	1.185		1.180"	1.180"	1.180"	1.180"		
E	0.365	0.385		.377"	.377"	.377"	.377"		
F	0.490	0.510		.498"	.497"	.498"	.499"		
H	R.470	R.530		R.525"	R.525"	R.525"	R.525"		
I	R1.575	R1.595		R1.587"	R1.586"	R1.588"	R1.585"		
J	0.240	0.260		.256"	.260"	.257"	.255"		
K	0.490	0.510		.500"	.500"	.500"	.500"		
L	3.590	3.650		3.620"	3.620"	3.620"	3.620"		
M	0.315	0.320		Ø .320"	Ø .320"	Ø .320"	Ø .320"		
N	0.256	0.262		Ø .259"	Ø .259"	Ø .259"	Ø .259"		
O	6.500	6.520		6.510"	6.510"	6.510"	6.511"		
P	5.990	6.010		5.997"	5.993"	6.000"	6.000"		
Q	2.820	2.830		2.825"	2.825"	2.825"	2.825"		
R	2.495	2.505		2.502"	2.502"	2.502"	2.502"		
S	2.245	2.255		2.253"	2.253"	2.253"	2.253"		
T	1.120	1.130		1.126"	1.126"	1.126"	1.126"		
U	0.540	0.560		.546"	.443"	.446"	.499"		
V	0.793	0.803		.798"	.798"	.798"	.798"		
W	R.240	R.260		R.250"	R.250"	R.250"	R.250"		
X	0.040	0.060		.045"	.045"	.045"	.045"		
Y	0.100	0.120		.110"	.110"	.110"	.110"		
AA	R1.125	R1.145		R1.136"	R1.134"	R1.137"	R1.134"		
AB	R.490	R.510		R.500"	R.500"	R.500"	R.500"		
AC	0.615	0.635		.635"	.635"	.635"	.635"		
AD	0.240	0.260		.252"	.256"	.254"	.251"		
AE	1.810	1.830		1.823"	1.823"	1.823"	1.823"		
AF	0.240	0.260		.248"	.248"	.249"	.249"		
AG	0.140	0.160		.152"	.153"	.153"	.153"		
AH	0.140	0.160		.151"	.154"	.153"	.151"		
AI	0.140	0.160		.154"	.160"	.155"	.152"		
Accept/Reject									

Measured by:	J.F.
Date:	07/04/13

Audited by:	Jnl
Date:	07/04/15

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	Jnl

DART AEROSPACE LTD		Work Order:	31076
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		Ø.486"	Ø.486"	Ø.486"	Ø.486"		
B	1.175	1.185		1.180"	1.180"	1.180"	1.180"		
C	3.145	3.155		3.150"	3.150"	3.150"	3.150"		
D	1.175	1.185		1.180"	1.180"	1.180"	1.180"		
E	0.365	0.385		.377"	.377"	.377"	.377"		
F	0.490	0.510		.499"	.500"	.499"	.500"		
H	R.470	R.530		R.525"	R.525"	R.525"	R.525"		
I	R1.575	R1.595		R1.587"	R1.586"	R1.584"	R1.585"		
J	0.240	0.260		.258"	.255"	.259"	.257"		
K	0.490	0.510		.499"	.500"	.500"	.500"		
L	3.590	3.650		3.620"	3.620"	3.620"	3.620"		
M	0.315	0.320		Ø.320"	Ø.320"	Ø.320"	Ø.320"		
N	0.256	0.262		Ø.259"	Ø.259"	Ø.259"	Ø.259"		
O	6.500	6.520		6.510"	6.510"	6.510"	6.510"		
P	5.990	6.010		6.000"	6.000"	6.000"	6.000"		
Q	2.820	2.830		2.825"	2.825"	2.825"	2.825"		
R	2.495	2.505		2.502"	2.502"	2.502"	2.502"		
S	2.245	2.255		2.253"	2.253"	2.253"	2.253"		
T	1.120	1.130		1.126"	1.126"	1.126"	1.126"		
U	0.540	0.560		.550"	.551"	.550"	.550"		
V	0.793	0.803		.798"	.798"	.798"	.798"		
W	R.240	R.260		R.250"	R.250"	R.250"	R.250"		
X	0.040	0.060		.045"	.045"	.045"	.045"		
Y	0.100	0.120		.110"	.110"	.110"	.110"		
AA	R1.125	R1.145		R1.136"	R1.135"	R1.133"	R1.133"		
AB	R.490	R.510		R.500"	R.500"	R.500"	R.500"		
AC	0.615	0.635		.635"	.635"	.635"	.635"		
AD	0.240	0.260		.251"	.253"	.253"	.253"		
AE	1.810	1.830		1.823"	1.823"	1.823"	1.823"		
AF	0.240	0.260		.249"	.249"	.248"	.249"		
AG	0.140	0.160		.154"	.153"	.153"	.154"		
AH	0.140	0.160		.152"	.152"	.152"	.152"		
AI	0.140	0.160		.152"	.152"	.153"	.153"		
Accept/Reject									

Measured by:	J.F.
Date:	07/04/03

Audited by:	gmk
Date:	07/04/15

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

DART AEROSPACE LTD		Work Order:	31076
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		0.486"					
B	1.175	1.185		1.180"					
C	3.145	3.155		3.150"					
D	1.175	1.185		1.180"					
E	0.365	0.385		0.377"					
F	0.490	0.510		0.500"					
H	R.470	R.530		R.525"					
I	R1.575	R1.595		R1.584"					
J	0.240	0.260		0.257"					
K	0.490	0.510		0.499"					
L	3.590	3.650		3.620"					
M	0.315	0.320		0.320"					
N	0.256	0.262		0.259"					
O	6.500	6.520		6.509"					
P	5.990	6.010		5.999"					
Q	2.820	2.830		2.825"					
R	2.495	2.505		2.502"					
S	2.245	2.255		2.253"					
T	1.120	1.130		1.126"					
U	0.540	0.560		0.549"					
V	0.793	0.803		0.798"					
W	R.240	R.260		R.250"					
X	0.040	0.060		0.045"					
Y	0.100	0.120		0.110"					
AA	R1.125	R1.145		R1.133"					
AB	R.490	R.510		R.500"					
AC	0.615	0.635		0.625"					
AD	0.240	0.260		0.251"					
AE	1.810	1.830		1.823"					
AF	0.240	0.260		0.249"					
AG	0.140	0.160		0.153"					
AH	0.140	0.160		0.152"					
AI	0.140	0.160		0.154"					
Accept/Reject									

Measured by:	J.F.
Date:	07/09/13

Audited by:	QML
Date:	07/04/15


Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

DART AEROSPACE LTD		Work Order:	31076
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490							
B	1.175	1.185							
C	3.145	3.155							
D	1.175	1.185							
E	0.365	0.385							
F	0.490	0.510							
H	R.470	R.530							
I	R1.575	R1.595							
J	0.240	0.260							
K	0.490	0.510							
L	3.590	3.650							
M	0.315	0.320							
N	0.256	0.262							
O	6.500	6.520							
P	5.990	6.010							
Q	2.820	2.830							
R	2.495	2.505							
S	2.245	2.255							
T	1.120	1.130							
U	0.540	0.560							
V	0.793	0.803							
W	R.240	R.260							
X	0.040	0.060							
Y	0.100	0.120							
AA	R1.125	R1.145							
AB	R.490	R.510							
AC	0.615	0.635							
AD	0.240	0.260							
AE	1.810	1.830							
AF	0.240	0.260							
AG	0.140	0.160							
AH	0.140	0.160							
AI	0.140	0.160							
Accept/Reject									

Measured by:	
Date:	

Audited by	
Date:	


Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

DART AEROSPACE LTD		Work Order:	31076
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1	

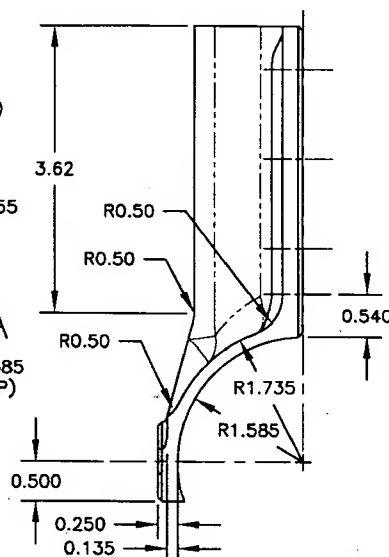
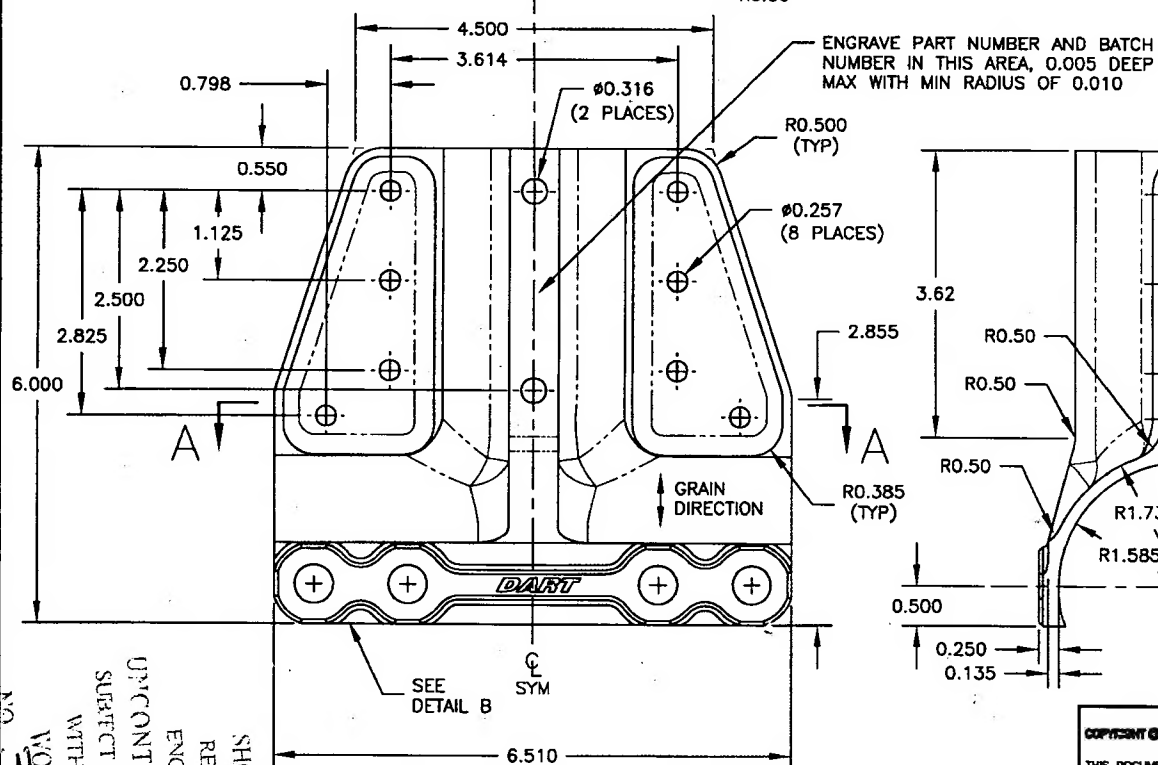
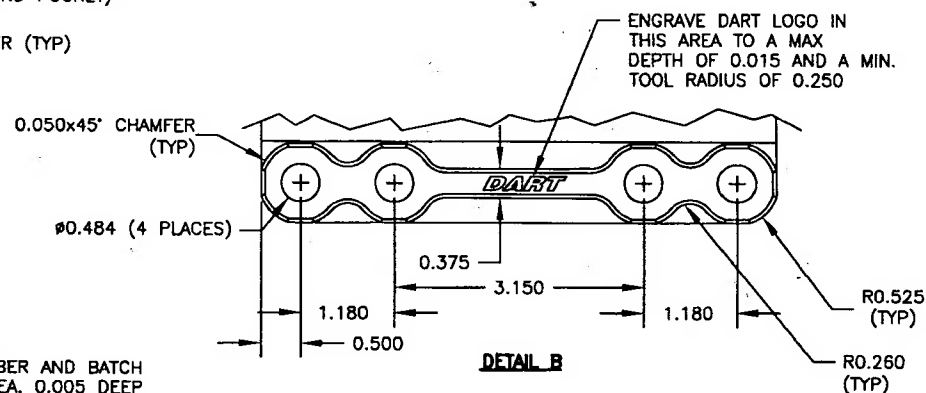
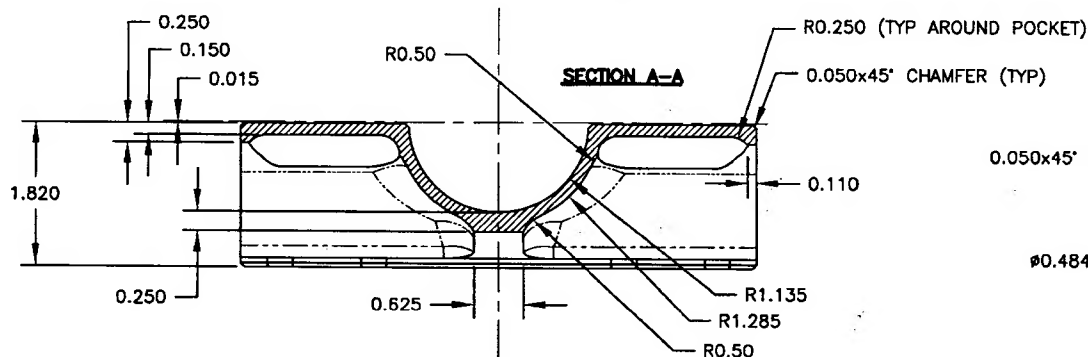
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490							
B	1.175	1.185							
C	3.145	3.155							
D	1.175	1.185							
E	0.365	0.385							
F	0.490	0.510							
H	R.470	R.530							
I	R1.575	R1.595							
J	0.240	0.260							
K	0.490	0.510							
L	3.590	3.650							
M	0.315	0.320							
N	0.256	0.262							
O	6.500	6.520							
P	5.990	6.010							
Q	2.820	2.830							
R	2.495	2.505							
S	2.245	2.255							
T	1.120	1.130							
U	0.540	0.560							
V	0.793	0.803							
W	R.240	R.260							
X	0.040	0.060							
Y	0.100	0.120							
AA	R1.125	R1.145							
AB	R.490	R.510							
AC	0.615	0.635							
AD	0.240	0.260							
AE	1.810	1.830							
AF	0.240	0.260							
AG	0.140	0.160							
AH	0.140	0.160							
AI	0.140	0.160							
Accept/Reject									

Measured by:	
Date:	

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

4



D3500-1 SADDLE

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/11) (MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1, POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED

06-08-15

C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	DP	DRAWN BY PH
CHECKED	4	APPROVED 4
DATE	06.06.30	DRAWING NO. D3500
		TITLE SADDLE
		REV. C SHEET 1 OF 1
		SCALE 2:3

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WARRICKBURT, OXFORD, CANADA

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